



Evolution NX6504 Transparent Base

Evolution NX6550 Opaque Base

Evolution NX6504 Transparent Base and Evolution NX6550 Opaque Base are mixing bases formulated to be used by themselves or mixed together with Evolution PCPro Pigment Concentrates to produce colors for printing on white or light-colored garments or on top of NX6581 Optical White when printing on dark garments. Depending upon the degree of opacity required in the colour formula, or for the application, the NX6550 Opaque Base may also be necessary to accurately reproduce the colour. Colours mixed with these bases will have little or no bleed-resistance on dark polyester blends and should be used only in designs printed on 100% cotton garments. These bases are used to produce the 11 colors of the ColorPro Color Matching System. Inks made with this base do not offer bleed-resistance and if printed on 50/50 cotton/poly blends or 100% polyester, should be underbased with the appropriate Evolution NX Defender dye blocker to prevent dye migration.

Technical Information

Software—ColorPro Software may be used to mix all standard Evolution NX standard colors, all Pantone® C Colors and any custom color. The PC-based software can be downloaded from a link provided on the home page at www.lancergroup.com.

Mixing--Do not overload bases with pigments. Evolution Pigment Concentrates are highly-concentrated. Recommended pigment loads in the appropriate base is 15% and at no time should ever exceed 20% by weight. Over-pigmentation of base could result in crocking or curing problems. Color accuracy should be evaluated by printing through same mesh size on like substrate after complete curing. Because of improvements in NX System Bases crock testing may be done immediately after curing once print has cooled completely.

Mesh—Mesh sizes between 110T and 305T (43T-120T metric) are recommended but should be determined after consideration of artwork and desired end result of decoration.

Gel Temperature— Inks will gel when surface temperature reaches 220°-240° F (110°-120° C.)

Curing— When printing on 100% cotton fabrics mixed inks fully cure when the entire ink film reaches 310°-320° F (155°-160° C) for 45 seconds to 1 minute inside the dryer. Colours made from NX6504 or NX6550 do not offer any bleed-resistance. On dark-coloured 50/50 cotton/poly blends or 100% polyester fabrics dye migration may be controlled by lowering dryer temperature to 275° Fahrenheit (135°-137° Celsius) for two minutes. However, if printed on dark-coloured 50/50 cotton/poly blends or 100% polyester fabrics known for dye migration colours should be underbased with the appropriate **Evolution Defender** dye blocker and NX6581 Optical White.

Reducer—Do not add Viscosity Reducer NX6390 (1-3% maximum) until viscosity is evaluated after thoroughly stirring the ink.

Ink Cleanup—Use Enviro Series 2000 Green or Enviro Series TR Blend.

Storage—Base and mixed ink should be stored at temperatures less than 30°C/84°F. Extended storage in warmer conditions can cause inks to thicken.

Caution

Always test finished prints for color accuracy, curing, adhesion, opacity, crocking, stretch and desired look prior to beginning full production runs. Lancer Group International cannot guarantee the results or back claims that this ink will test PVC-free or phthalate-free if any pigment or additive other than an Evolution Pigment Concentrate or Evolution NX System additive that has been manufactured by Lancer Group International is used in this ink. Contamination can also occur from mixing tools, mixing buckets, spatulas, squeegees, or flood bars that have had prior contact with inks containing PVC's or phthalates and these tools must be thoroughly cleaned before using with the NX System.

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